

Work Order ID 80492

February-21-12 3:10:09 PM

80492

1 Don Shepherd

Page 1

Item ID: D206-817-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Screw-In Windshield, LH/RH

Start Date: 21/02/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: *M.L.J* Date: *12/02/20* Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N):

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-817	B

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-817-011 CHG001								

M 12 03 23 ①
for M.L.S 12-3-20

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

6/23/20 ①

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

M 12 03 23 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-817-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Screw-In Windshield, LH/RH

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-817-011 Location: _____

PPP Rev: _____

12/3/23 5/12

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ 12/03/26

RD3393

me
12-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 80492

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Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4543-1 *D4543-1* Retainer, Outer, LH		Manufactured	No			110	Each	0.0000	1 2	2			
D4543-2 *D4543-2* Retainer, Outer, RH		Manufactured	No			110	Each	0.0000	1 2	2			
D4543-3 *D4543-3* Retainer, Outer, LH		Manufactured	No			110	Each	0.0000	1 2	2			
D4543-4 *D4543-4* Retainer, Outer, RH		Manufactured	No			110	Each	0.0000	1 2	2			
D4544-1 *D4544-1* Retainer, Center		Manufactured	No			110	Each	1.0000	1 2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				hai		1							
D4545-041 *D4545-041* Retainer, Inner, LH (Lower)		Manufactured	No		79386	110	Each	0.0000	1 2	2			
D4545-042 *D4545-042* Retainer, Inner, RH (Lower)		Manufactured	No			110	Each	0.0000	1 2	2			
D4545-043 *D4545-043* Retainer, Inner, LH (Side)		Manufactured	No			110	Each	0.0000	1 2	2			

CP Rev 1.03
1 replacement

80492
1 replacement

389425

3819375

38939 12/3/23
1 replacement

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 80492

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Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

nm	D4545-044	Manufactured	No	110	Each	0.0000
	D4545-044					
	Retainer, Inner, RH (Side)					
nm	D4545-045	Manufactured	No	110	Each	0.0000
	D4545-045					
	Retainer, Inner, LH (Top Corner)					
m	D4545-046	Manufactured	No	110	Each	0.0000
	D4545-046					
	Retainer, Inner, RH (Top Corner)					
nl	D4545-047	Manufactured	No	110	Each	0.0000
	D4545-047					
	Retainer, Inner, LH (Top)					
m	D4545-048	Manufactured	No	110	Each	0.0000
	D4545-048					
	Retainer, Inner, RH (Top)					
nm	D4594-1	Manufactured	No	110	Each	0.0000
	D4594-1					
	Plate					
nm	AN525-10R7	Purchased	No	110	Each	168.0000
	AN525-10R7					
	Screw					

** 12/21/03 (381938) I represent
 ** 381936 sp
 ** 381935 sp
 ** 381941 sp
 ** 381940 sp 12/3/13
 ** 80506
 ** 120833 12/3/13

Location

Loc Qty

Loc Code

ST345	168
115371	24
116737	44
118686	100

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 80492

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Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS21059L08

Purchased

No

110

Each

215.0000

23

✓ 46

MS21059I 08

Nut

**

Location

Loc Qty

Loc Code

ST300

215

112314

200

12706

15

112314

MS21075L08

Purchased

No

110

Each

364.0000

1

✓ 2

MS21075I 08

ANCHOR NUT

**

Location

Loc Qty

Loc Code

ST303

302

111578

2

120560

300

ST304

62

120121

62

120560

MS27039-08-10

Purchased

No

110

Each

168.0000

22

✓ 44

MS27039-08-10

Screw

**

Location

Loc Qty

Loc Code

Mezz

168

5865

168

5865

NAS1149DN832J

Purchased

No

110

Each

2,256.000

22

✓ 44

NAS1149DN832.I

WASHER

**

Location

Loc Qty

Loc Code

ST298

2256

119717

256

120422

2000

119717

PHO

W/O: 80492		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/03/23	110	Add Sealant Tape (25' long) to W/O. D4595-150-25 <i>permanent change</i>	12/03/23	12/03/23		<i>12/03/23</i>	<i>12/03/26</i>

Part No: D206-017-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DART AEROSPACE LTD.

IIN-D206-817

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4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4545-043	RETAINER, LH INNER (SIDE)
1	D4545-044	RETAINER, RH INNER (SIDE)
1	D4545-045	RETAINER, LH INNER (CORNER)
1	D4545-046	RETAINER, RH INNER (CORNER)
1	D4545-047	RETAINER, LH INNER (TOP)
1	D4545-048	RETAINER, RH INNER (TOP)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
23	MS21059L08	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)